



Dart Aerospace Ltd.
1270 Aberdeen St
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S169709

RBW109-3101-87-113

Job Sheet 189569



Part No: RBW109-3101-87-113

Job Qty: 1 pcs

Part Name: Tool Assembly, Main Rotor Grip Brushing Removal/Install



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/28/19

Job Tracking No:

Due Date: 4/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description: order 4624

Note: DWG RBW109-3101-87-113 Rev.3 IPP Rev. A 19.01.25 New issue DP Verify DD

Ship Via:



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Container No: S169709



Part: RBW109-3101-87-113

Job No: 189569

Serial No/Batch: S169709

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 04/04/19

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1200-E ^{60F}	Case	1 Ea (1 ea)	90-Small Fab - 1	5156580
91455A150 ⁷⁰	Washer, M12	2 Ea (2 ea)	100-Small Fab - 2 - B4B	5150671
92497A500	Nut M12	2 (2 ea)	100-Small Fab - 2 - B4B	5169681
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	100-Small Fab - 2 - B4B	5145165
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5021040
103 RBW109-3101-87-113-1	Reaction, Support Pressure	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5162954
60F RBW109-3101-87-113-11	Bottom Tool Cushion use in case APP-1200-E	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5156587
102 RBW109-3101-87-113-13	Top Tool Cushion use in case APP-1200-E	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5156585
105 RBW109-3101-87-113-15	Placard	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5134421
105 RBW109-3101-87-113-3	Guide	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5165095
103 RBW109-3101-87-113-5	Disk	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5163329
64 RBW109-3101-87-113-7	Reaction, Support Pressure	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5162903
	Turnbuckle	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5162337

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Small Fab - 1	APP-1200-E	1	14	0
100-Small Fab - 2 - B4B	91455A150	2	50	0
	92497A500	2	0	0
	97524A032	4	221	0
	RB41011	1	380	0
	RBW109-3101-87-113-1	1	0	0
	RBW109-3101-87-113-11	1	1	0
	RBW109-3101-87-113-13	1	1	0
	RBW109-3101-87-113-15	1	4	0
	RBW109-3101-87-113-3	1	0	0
	RBW109-3101-87-113-5	1	0	0
	RBW109-3101-87-113-7	1	0	0
	RBW109-3101-87-113-9	1	4	0

Part Specifications

Specifications could not be found.

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Job Sheet 189569



Part No: RBW109-3101-87-113

Job Qty: 1 pcs

Part Name: Tool Assembly, Main Rotor Grip Brushing Removal/Install



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/28/19

Job Tracking No:

Due Date: 3/26/19

Created By: Marie Lajeunesse

Type: SOLD

Description: order 4624

Note: DWG RBW109-3101-87-113 Rev.3 IPP Rev. A 19.01.25 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	3/26/19		0.00	0.20	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	3/26/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Packaging 3-1 - Stock - B4B	1 pcs	3/26/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - FG	1 pcs	3/26/19		0.00	0.00	QC 21 - FG - 21		

Part Op 100 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
 Descriptions: APP-1200-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW109-3101-87-113-15 to RBW109-3101-87-113-13 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91455A150	Washer, M12	2 Ea (2 ea)	100-Small Fab - 1	
92497A500	Nut M12	2 (2 ea)	100-Small Fab - 1	
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	100-Small Fab - 1	
APP-1200-E	Case	1 Ea (1 ea)	100-Small Fab - 1	
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	100-Small Fab - 1	
RBW109-3101-87-113-1	Reaction, Support Pressure	1 pcs (1 ea)	100-Small Fab - 1	
RBW109-3101-87-113-11	Bottom Tool Cushion	1 (1 ea)	100-Small Fab - 1	
RBW109-3101-87-113-13	Top Tool Cushion	1 (1 ea)	100-Small Fab - 1	
RBW109-3101-87-113-15	Placard	1 pcs (1 ea)	100-Small Fab - 1	
RBW109-3101-87-113-3	Guide	1 pcs (1 ea)	100-Small Fab - 1	
RBW109-3101-87-113-5	Disk	1 pcs (1 ea)	100-Small Fab - 1	
RBW109-3101-87-113-7	Reaction, Support Pressure	1 pcs (1 ea)	100-Small Fab - 1	
RBW109-3101-87-113-9	Turnbuckle	1 pcs (1 ea)	100-Small Fab - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	91455A150	2	0	0
	92497A500	2	0	0
	97524A032	4	739	0
	APP-1200-E	1	19	0
	RB41011	1	482	0
	RBW109-3101-87-113-1	1	0	0
	RBW109-3101-87-113-11	1	0	0
	RBW109-3101-87-113-13	1	0	0
	RBW109-3101-87-113-15	1	0	0
	RBW109-3101-87-113-3	1	0	0
	RBW109-3101-87-113-5	1	0	0
	RBW109-3101-87-113-7	1	0	0
	RBW109-3101-87-113-9	1	0	0

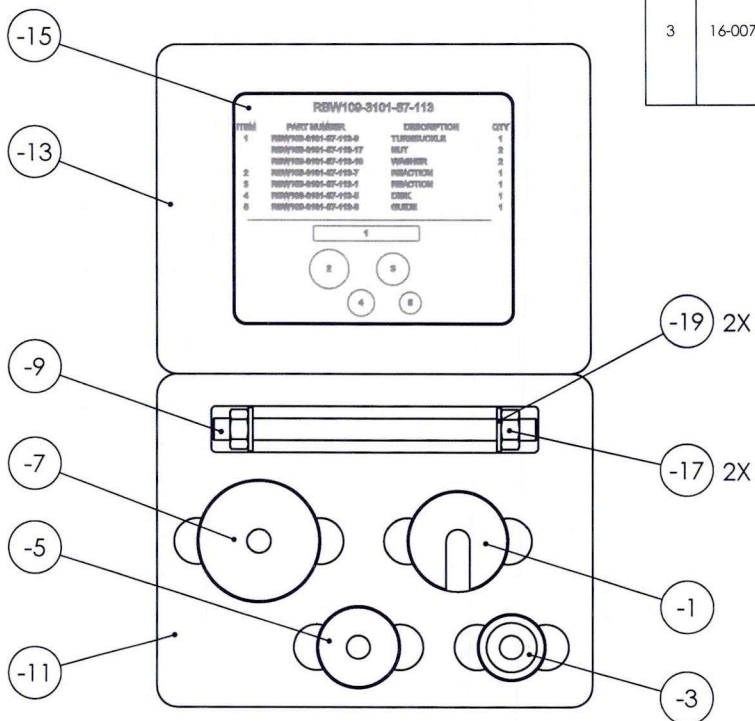
Part Specifications

Specifications could not be found.

Plex 1/28/19 1:49 PM Dart.lajeunesse.marie

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
2	15-0283	-1 CH'D ENGRAVE NOTE WAS ENGRAVE RBW109-3101-87-103 IS ENGRAVE P/N, ADDED 4142 Q&T TO MATERIAL CALL OUT. -3 CH'D ENGRAVE NOTE WAS ENGRAVE RBW109-3101-87-103 IS ENGRAVE P/N, ADDED 4142 Q&T TO MATERIAL CALL OUT. -5 CH'D ENGRAVE NOTE WAS ENGRAVE RBW109-3101-87-107 IS ENGRAVE P/N, ADDED 4142 Q&T TO MATERIAL CALL OUT. -7 CH'D ENGRAVE NOTE WAS ENGRAVE RBW109-3101-87-109 IS ENGRAVE P/N, ADDED 4142 Q&T TO MATERIAL CALL OUT. -15 CORRECTED P/N'S ON PLACARD WAS RBW109-3101-87-113-XX IS RBW109-3101-87-113-17, WAS RBW109-3101-87-113-XX IS RBW109-3101-87-113-19.			9/1/2015	RJC	JAG
3	16-0077	UPDATED TO NEW STANDARD. -1, -3, -5, -7 CH'D FINISH WAS CAD PLATE YELLOW QQ-P-416, TYPE II, CLASS II IS ZINC PLATE ASTM B633 TYPE I SC 2. CH'D MAT'L WAS 4140 Q&T/4142 Q&T IS 4140/4142. ADDED HEAT TREAT RC 28-34. -9 ADDED FINISH AND SPEC. -11 CH'D DIMS WAS 2X 1.30 IS 6X 1.30, WAS 2X 3.60 IS 6X 3.60. DELETED DIM 4X R.44. ADDED DIMS .87, 3.53, 3.54, 5.25, 5.41, 6.93, 7.60, 8.40, 4X 45°, 4X .60. -13 CH'D DIMS WAS 1.10 IS 1.07, WAS 5.00 IS 5.06, WAS 1.69 IS 1.66, WAS 6.00 IS 6.06, WAS R.13 IS R.28. DELETED DIM 4X R.44. ADDED DIMS 4X 45°, 4X .60. -11 & -13 CH'D B/O REF WAS I.R. SPECIALTY IS (CASE SOLUTIONS). CH'D MAT'L WAS Y-20 BLACK IS ETHAFOAM 220, BLACK. -11, -13, -15 CH'D TITLE BLOCK TOLERANCES WAS ± .005 IS ± .010, WAS ±.01 IS ±.03. ADDED DART PLACARD RB41011.			7/15/2016	DEW	SM



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WORK ORDER

NO. 189569MWS
19-01-28

NOTE:
REF. AGUSTA T/N: 109-3101-87-113.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	REACTION, SUPPORT PRESSURE	4140/4142		2
			-3	1	GUIDE	4140/4142		3
			-5	1	DISK	4140/4142		4
			-7	1	REACTION, SUPPORT PRESSURE	4140/4142		5
			-9	1	TURNBUCKLE	STEEL	M12 X 1.75 MCMASTER-CARR #99067A254 (MODIFIED)	6
		B/O	-11	1	BOTTOM TOOL CUSHION	ETHAFOAM 220, BLACK	9.41 X 7.23 X 2.93 (CASE SOLUTIONS)	7
		B/O	-13	1	TOP TOOL CUSHION	ETHAFOAM 220, BLACK	9.37 X 7.19 X 1.19 (CASE SOLUTIONS)	8
			-15	1	PLACARD	PLASTIC		9
		B/O	-17	2	NUT	STEEL	M12 X 1.75 (MCMASTER-CARR #92497A500)	1
		B/O	-19	2	WASHER	STEEL	M12 (MCMASTER-CARR #91455A150)	1
		B/O	-21	1	CASE	PLASTIC	PELICAN #APP-1200-E BLACK	N/S
		B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S

DART AEROSPACE			
TITLE TOOL ASSY, M/R GRIP BUSHINGS REM/INSTL			
DWG NO. RBW109-3101-87-113			REV 3
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
DRAWN BY: GILBERT		X ± .1 SURFACES = 125°	
CHECKED: CLOUGH		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: MACKOVJAK		AFTER PLATING	
SCALE 1:4		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 2/25/2014		USED ON MODEL	
SHEET 1 OF 9		AW109, AW119	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					